

MARLBORO STANDARDIZATION

TEST PLAN - RUN NO. 4

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Marlboro Standardization Group

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SECTION I - INTRODUCTION

Plans are to conduct Marlboro Standard Run No. 4 at the four cigarette factories and at the R&D Semi-works during the week of February 9, 1987. Plans for each factory and for the Semi-works are covered in following sections of this document.

Marlboro Y might also be produced during the same week.

Objectives of Run No. 4 follow:

1. Confirm the trends of panel results obtained from the monthly pick-ups and previous standard runs.
2. Confirm the baseline with regard to formula changes.
3. Compare Standard No. 4 to Marlboro Y and the previous standards.
4. Compare processing profiles with regard to temperatures, OV's, sieves and times.
5. Compare cigarettes with regard to normal cigarette physical data such as CV, OV, weight, firmness, loose ends, etc., as reported by factory QA tests.
6. Compare analytical data.

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SECTION II - TEST PLAN DESCRIPTION

1. M/C Primary, using DET2MS; no rippers; and other MS components, will make 40,000 pounds each of KS and LS cut filler. M/C Cigarette Manufacturing, using the cut filler and standardization packing materials, will make and pack at least 1 million each of KS and LS cigarettes for sampling.
2. Louisville plan is the same as M/C plan except Primary will use ET2MS for MS Run No. 4.
3. S/S plan is the same as M/C except Primary will use ET2MS and process 20,000 pounds each of KS and LS cut filler.
4. Cabarrus plan is the same as M/C.
5. R&D Semiworks plan is to use DET2MS and ET2MS separately and MS components to process cut filler and produce MKS using standardization packaging materials.
6. See SECTION VII - Sampling Requirements.

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SECTION III - STANDARD MS COMPONENTS

1. The respective processing plants will produce and provide the following:
 - ET2MS
 - DET2MS
 - ESMS
 - ESB-2MS (Annex for Lville and Cab; M/C for M/C and S/S)
 - MTMS
 - RCB1MS
 - RL1MS
 - RLB1MS
 - Flavor concentrates
 - Tipping paper
2. Bright and Burley will be normal DBC per blend sheets.
3. See Section VII - Sampling Requirements.

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SECTION IV - STANDARD PACKAGING MATERIALS

1. Each cigarette fabrication facility will receive standardization packaging materials of the same lot divided among the locations:
 - Tipping paper
 - Cigarette paper
 - Roll labels
 - Blanks
 - Inner-frame
 - Foil-Soft pack
 - Foil-Box
 - Film
 - Tear tape
 - Carton blanks
 - Tow
 - PZ
 - Plug wrap
2. See Appendix I for MKS materials specification.
3. See Appendix II for MLS materials specification.

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SECTION V - PRIMARY

1. A list of standard components and materials to be furnished is shown in Section III.
2. All locations shall use no rippers in the finished filler.
3. See Section VII - Sampling Requirements.
4. See Appendices III and IV for the data forms which list the data required from Marlboro Standard Run No. 4. Enter the required data on a data diskette to be provided by the Marlboro Standardization Group and send a copy of the diskette to R. Markwood, O/C, T2E, Richmond.
5. OV data shall be the average of at least 3 determinations.
6. Temperatures shall be the average of at least 3 determinations. Use a "heat gun" aimed at the center of each grab sample as soon as the sample is "opened" for each determination. Repeat 3 times. USE GLOVES AND EXERCISE EXTREME CARE WHEN OBTAINING GRAB SAMPLES.

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SECTION VI - FABRICATION

1. See Section IV and Appendices I and II for a list of standard packaging materials to be provided.
2. See Section VII - Sampling Requirements.
3. Prior to collecting cigarette samples, empty the Oscar, purge the module and restart to assure sample cigarettes are made from the test filler and standardization packaging materials.
4. For each maker/packer/module, record the following information and send a copy to R. Markwood, O/C, T2E, Richmond:
 - Module/maker/packer identification
 - Time and date of sample collection
 - Sample identification
 - Maker speed
 - Side seam adhesive identification
 - Tipping adhesive identification
 - Label/blank adhesive identification
 - Heater temperature
5. See Appendix IV for the data form which lists the data required from Marlboro Standard Run No. 4. Enter the data on a data diskette to be provided by the Marlboro Standardization Group. Send a copy of the data diskette to R. Markwood, O/C, T2E, Richmond.

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SECTION VII - SAMPLING REQUIREMENTS

1. Each processing plant (ET, DET, Oriental, RL, RCB, ES, ESB) will ship a one case or one HHD sample of the MS product to:

A. M. Gorman
Operations Center, Door 104, Gate S
2000 Bells Road
Richmond, VA

The Flavor Center will send a one quart sample of each flavor concentrate to:

R. A. Tierney
Same address as above

2. Sample Containers and Labels- Labeled sample containers will be supplied to each location for the following:

- Burley spray
- Burley top casing
- Bright casing
- After cut flavor
- Side seam adhesive
- Tipping adhesive

Identifying labels will be supplied for the 12M cigarette cases.

3. Primary Processing - for each cut filler produced, take samples as follows and send to R. A. Tierney, address as above:

- DBC Bright - 20 lb.
- DBC Burley - 20 lb.
- Cut filler exit flavor cylinder - 20 lb.
- Cut filler exit silo - 20 lb.
- Burley spray(frozen) - 1 qt.
- Bright casing(frozen) - 1 qt.
- Burley top casing - 1 qt.
- After cut flavor - 1 qt.

CONTINUED ON NEXT PAGE

SAMPLING REQUIREMENTS - Continued

4. Cigarette Manufacturing:

A. Adhesives: 1 qt sample at X as follows:

	KS		LS	
	start	finish	start	finish
Sample location:				
roll around tank:				
side seam	X	-	X	-
tipping	X	-	X	-
reservoir:				
side seam	X	X	X	X
tipping	X	X	X	X
glue pot:				
tipping (Max only)	-	X at clean-up	-	X at clean-up

B. Cigarettes

Factory	Number of 12 M Cases	
	KS	LS
MC	37	37
S/S	37	37
LVL	37	20
CAB	37	20
SEMI-WORKS(DET)	37	--
SEMI-WORKS(ET)	20	--

Send adhesives samples to:

R. H. Cox
B Building, R&D
Commerce Road
Richmond, VA

Send cigarette samples to:

R. A. Tierney
Operations Center, Door 104, Gate S
2000 Bells Road
Richmond, VA

APPENDIX I

MKS - MS #4 SPECS

ITEM -----	M/C -----	LVL -----	S/S -----	CAB -----	SEMI-WORKS -----
PZ	TO BE SPECIFIED BY OPERATIONS SERVICES				
TOW	TO BE SPECIFIED BY OPERATIONS SERVICES				
PLUG WRAP	06-157-A ECUSTA	SAME	SAME	SAME	SAME
TIPPING	12-431-H HERMETITE	SAME	SAME	SAME	SAME
CIG PAPER	10-023-A ECUSTA	SAME	SAME	SAME	SAME
LABELS	1L-291-A CHP	SAME	SAME	SAME	AMF
CLOSURE	40-101-B FERGUSSON	SAME	SAME	SAME	40-100-E
FOIL	15-160-A GOLDEN BELT	SAME	SAME	SAME	SAME
FILM	44-194-A HERCULES	SAME	SAME	SAME	SAME
TEAR TAPE	47-160-A ARLIN	SAME	SAME	SAME	SAME
CARTON	1C-290-A VA FOLD BOX	SAME	SAME	SAME	SAME
CASE	54-290-T WESTVACO	54-290-T BOISE CASCADE	54-290-T WESTVACO	54-290-T WEYER- HAEUSER	54-290-T WESTVACO

NOTE: "SAME" MEANS SAME SPEC AS M/C

APPENDIX II

MLS - MS #4 SPECS

ITEM -----	M/C -----	LVL -----	S/S -----	CAB -----
PZ	TO BE SPECIFIED BY OPERATIONS SERVICES			
TOW	TO BE SPECIFIED BY OPERATIONS SERVICES			
PLUG WRAP	06-276-A DEXTER	SAME	SAME	06-205-A KC
TIPPING	12-418-E CH	SAME	SAME	SAME PERFORATED TO CAB SPEC (12-406-G)
CIG PAPER	10-023-A ECUSTA	SAME	SAME	SAME
I-FRAME	20-001-A WESTVACO	SAME	SAME	SAME
BOX BLANK	1F-018-A CHP	SAME	SAME	SAME
FOIL	15-125-A REYNOLDS	SAME	SAME	SAME
FILM	44-154-A HERCULES	SAME	SAME	SAME
TEAR TAPE	47-160-A ARLIN	SAME	SAME	SAME
CARTON	1C-014-A RICHMOND GRAVURE	SAME	SAME	SAME
CASE	54-012-P INLAND	SAME	SAME	54-012-P OWENS-ILLINOIS

NOTE: "SAME" MEANS SAME SPEC AS M/C

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APPENDIX III

DATA FORM

PRIMARY PROCESS THRU CUTTING

(SEE APPENDIX IV FOR DATA FORMS COVERING DRYING THRU MAKE-PACK)

The following data form - 6 pages - lists the process data to be taken and reported for Marlboro Standard Run No. 4, beginning with containers entering the Vacuum Conditioners and ending with cut filler exiting the cutters. These data are to be common for both king size and long size cigarette filler processing.

NOTE: Process data are required from selected HHDs and other containers of ALL components. At the entrance to Vacuum Conditioning, select a container of each of 5 marks of Bright and a container of each of 5 marks of Burley as shown on the data form. Also, select a container of each of the other components to be conditioned. Tag the selected containers, and use them in obtaining the process data listed on the data form.

The data form is furnished only to the Primary and QA managers at each factory. Others may obtain a copy upon request by calling R. Markwood at 2320 in Richmond.

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APPENDIX IV

DATA FORM

PRIMARY PROCESS FROM CUTTING AND MAKE - PACK
(SEE APPENDIX III FOR DATA FORM COVERING VAC COND THRU CUTTING)

The following data forms list the data required to be taken and reported for Marlboro Standard Run No. 4, beginning with cut filler entering the cut filler dryers through make-pack. The form is specific for each location and cigarette as follows:

MC4KSD	covers M/C, run 4, Kingsize, DET expanded tobacco
MC4LSD	M/C, 4, Longsize, DET
CAB4KSD	CAB, 4, Kingsize, DET
CAB4LSD	CAB, 4, Longsize, DET
LV4KSE	LV, 4, Kingsize, ET
LV4LSE	LV, 4, Longsize, ET
SS4KSE	S/S, 4, Kingsize, ET
SS4LSE	S/S, 4, Longsize, ET
SW4KSD	Semi-Wks, 4, Kingsize, DET
SW4KSE	Semi-Wks, 4, Kingsize, ET

The forms are furnished only to the Primary, QA and Make-Pack Managers at the specific locations. Others may obtain a copy by calling R. Markwood at 2320 in Richmond.